

# Work Order ID 102397

**\*102397\***

Page 1

May-28-13 8:49:58 AM

Item ID: D6103-003 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Round Billet, Aluminum  
 Start Date: 5/27/13 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 5/27/13 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 13-05-29 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6103	Rev B								
100	PURCHASING	0.00							
<b>*100*</b>									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>FD10009</u> a) Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Tolerance on all dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*MLJ 12 5/29*

*13/2/3 (12)*

*13/07/03*

*12*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 102397

\*102397\*

Page 2

May-28-13 8:49:58 AM

Item ID: D6103-003

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Round Billet, Aluminum

Stop \*NS2\*

Start Date: 5/27/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/27/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: MAT43 0.00

\*130\*

Packaging

Memo

0.00

Packaging

OK 13/07/03

12

6

140

QC21- Final Inspection - Work Order Release 0.00

\*140\*

QC

Memo

0.00

Quality Control

13/7/4

mc

13-7-4

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

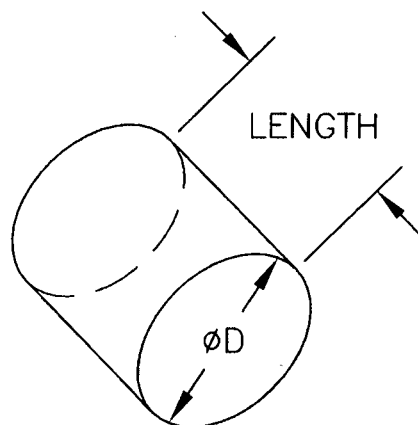
Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

## SPECIFICATION CONTROL DRAWING

RELEASED  
06.02.07 [Signature]



102397 MJS  
13-05-29  
[Vertical stamp]

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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**Castle Metals®**

A. M. Castle &amp; Co.

PACKING SLIP/  
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:1805178

<b>Ship From:</b> A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b>	<b>F.O.B.</b>	<b>Freight Terms</b>		<b>Carrier</b>		<b>BOL No</b>	
02-JUL-2013	ORIGIN	Prepaid		MANITOULIN		1805178-2	

<b>Shipment Details</b>	<b>Final Destination Branch - MON</b>
-------------------------	---------------------------------------

<b>Order No</b>	<b>Line No</b>	<b>Item No</b>	<b>Description</b>
2885790	2	8808.MO	3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN ( + .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: QQ-A-225/9

<b>Purchase Order No</b>	<b>Part Number</b>	<b>Ordered Qty</b>	<b>Invoice Qty</b>
20009	YOUR ITEM NUMBER: D6103-003	12.00 PCS	12.00 PCS

<b>Details</b>	END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS ECCN # EAR99
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<b>Delivery No.</b>	<b>Mill</b>	<b>Heat Number</b>	<b>Mech Id</b>	<b>PCS</b>	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty(LBS)</b>
118816523	KAISER ALUMINUM	10037991		5			60.6269
118816523	KAISER ALUMINUM	20169216		7			84.8776

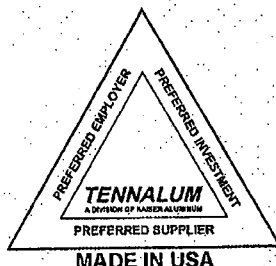
These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.			
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.			
Reviewed by Authorized Castle Metals Representative:		Date:	Name:





# KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum  
309 Industrial Drive  
Jackson, TN 38301  
731-423-2811



**CERTIFIED TEST REPORT**  
<http://Online.KaiserAluminum.com>

CUSTOMER PO NUMBER: 184087-1		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 682226	LINE ITEM: 1	SHIP DATE: 08/27/2012	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 1964 lbs.	QUANTITY: 14 pcs.	B/L NUMBER: 34385	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co 1420 Kensington Road Suite 220 Oak Brook, IL 60523 USA		

Test Code: 1000 AC

## Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
10037991	71.0	59.6	14.5	38.6

## Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.09	0.27	1.4	0.08	2.8	0.19	5.7	0.03			10037991
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

## Specifications

Standard: ISO 9001, ASTM B211-12, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-10

*13/07/03*  
*CRF*

## CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

*John Rennekamp*

Plant Serial: 177207

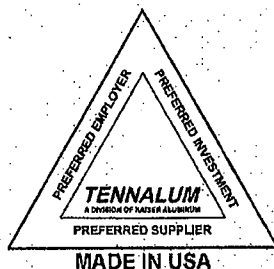
Kaiser Order Number: 682226

Line Item: 1



# KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum  
309 Industrial Drive  
Jackson, TN 38301  
731-423-2811



## CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

### Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements). No weld repair. Material is RoHS compliant.

### Castle Metals FP

HEAT NUMBER 10037991  
MECHANICAL ID \_\_\_\_\_  
ITEM CODE 2808  
LOT NUMBER \_\_\_\_\_  
PO NUMBER 184087  
RECEIPT DATE 8-28-12  
SUPPLIER KAISER  
SPECIFICATION \_\_\_\_\_  
LCS NO  
COMMENT \_\_\_\_\_  
APPROVED DL

*13/07/12*

### CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

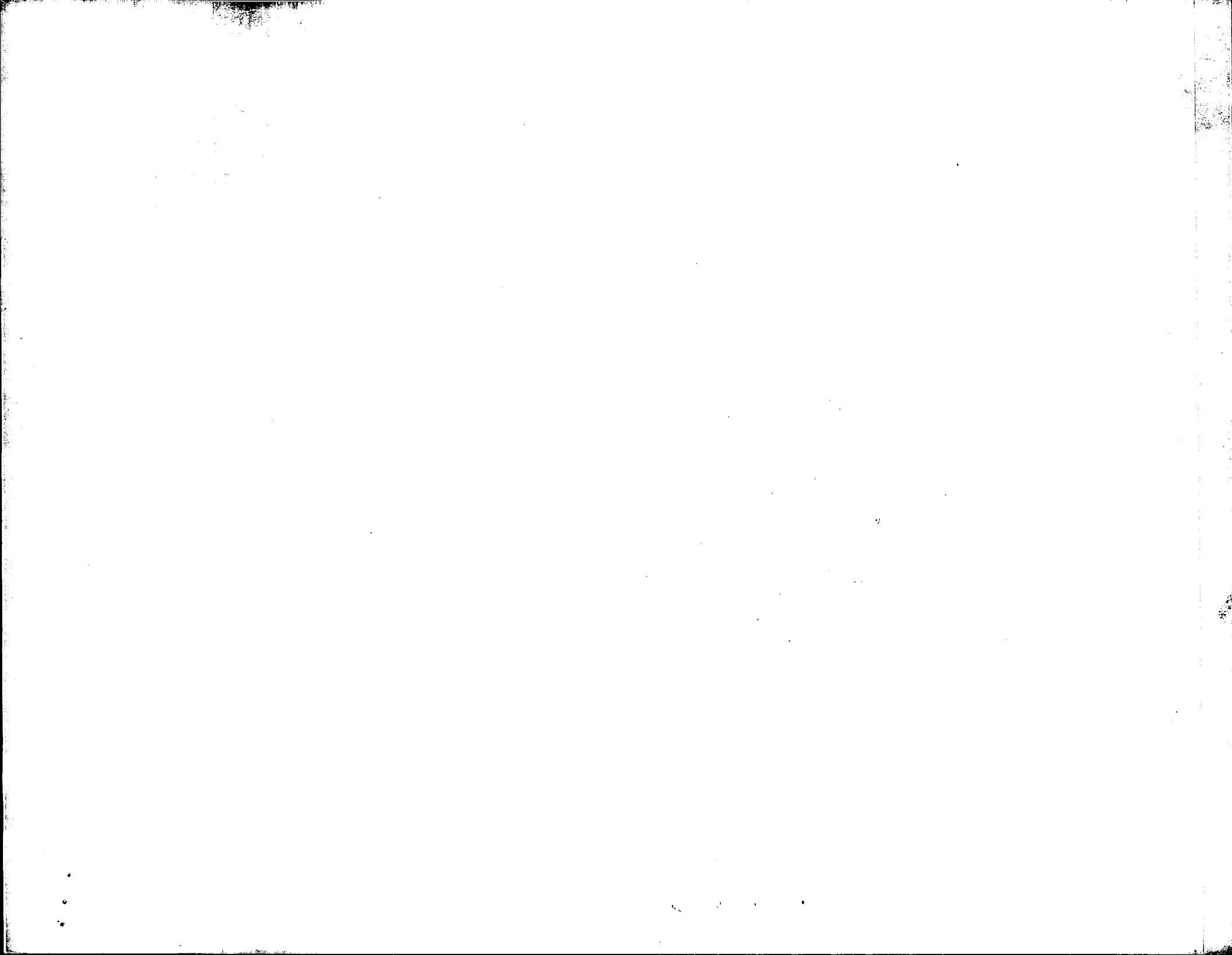
John Rennekamp, Quality Manager

*John Rennekamp*

Plant Serial: 177207

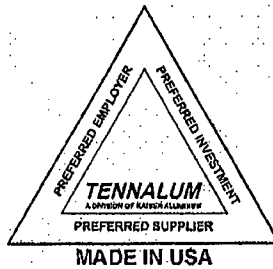
Kaiser Order Number: 682226

Line Item: 1



# KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum  
309 Industrial Drive  
Jackson, TN 38301  
731-423-2811



## CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

CUSTOMER PO NUMBER: 219076-1		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 687901	LINE ITEM: 1	SHIP DATE: 04/29/2013	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 1964 lbs.	QUANTITY: 14 pcs.	B/L NUMBER: 35327	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co 1420 Kensington Road Suite 220 Oak Brook, IL 60523 USA		

Test Code: 1000 AC

### Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20169216	69.7	57.6	16.5	39.9

### Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.08	0.23	1.4	0.03	2.7	0.19	5.9	0.02			20169216
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

### Specifications

Standard: ISO 9001,ASTMB211-12,AMS4124E,AMS-QQ-A-225/9 Non-Standard: A97075-11-R13

*13/07/13*  
*CR*

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John Rennekamp, Quality Manager

*John Rennekamp*

Plant Serial: 187383

Kaiser Order Number: 687901

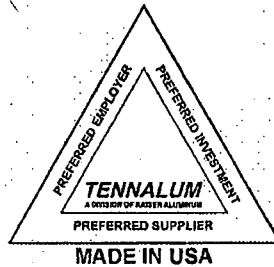
Line Item: 1



# KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum  
309 Industrial Drive  
Jackson, TN 38301  
731-423-2811



## CERTIFIED TEST REPORT

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Castle Metals FP

HEAT NUMBER 20169216  
MECHANICAL ID \_\_\_\_\_  
ITEM CODE 8808  
LOT NUMBER \_\_\_\_\_  
PO NUMBER 219076  
RECEIPT DATE 5-1-13  
SOURCER KAISER  
SPECIFICATION \_\_\_\_\_  
LCS NO  
COMMENT \_\_\_\_\_  
APPROVED B

CR 13/67/03

### CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

*John Rennekamp*

Plant Serial: 187383

Kaiser Order Number: 687901

Line Item: 1